



Dart Aerospace Ltd.
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20NR-64
Job Sheet 201050



Part No: 20NR-64

Job Qty: 9 pcs

Part Name: Flat Bumper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/23/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 9/26/19

Type: Stock

Description:

Note: 20NR-64 REV.A IPP REV:A 17.11.15 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - 1	9 pcs	9/26/19	9/26/19	0.00	1.00	External Load - 1		AP 2019/09/23
							External Load - 2		
							External Load - 3		
110	QC 5	9 pcs	9/26/19	9/26/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		DAS 40 SFP 23 2019 9-89
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	9 pcs	9/26/19	9/26/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		DAS 28 9-89
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Plex 9/23/19 10:17 AM dart.lacelle.linde		



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Container No: S216193



Part: 20NR-64

Job No: 201050

Serial No/Batch: S216193

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/23/19

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

140 QC 21 - SA

9 pcs

9/26/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

SEP 24 2019

DAS

70

9-89

Part Op 100 - Small Fab - 1-Mix 80A liquid urethane using base and activator as per manufacturer instructions. A/R;
 Descriptions: M 5170556 EXP. 10-01-2019 2-Pour into DT10517 Mold. 3-Let cure as per manufacturer instructions. Time;
11.30 4-Remove from mold. 5-Cut to length as per drawing. 6-Deburr if required.

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
8644K12	80A Liquid Urethane	.0090 pcs (.001 ea)	100-External Load - 1	<u>5170556</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-External Load - 1	8644K12	0	3	0

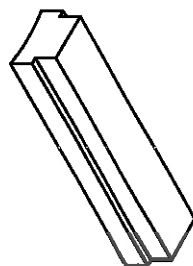
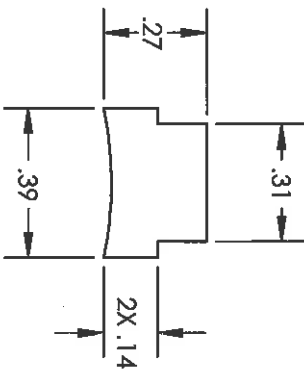
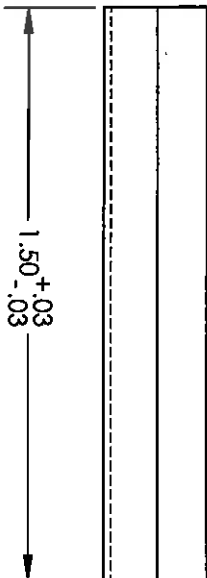
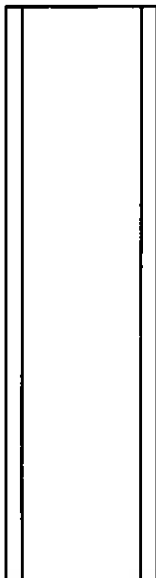
Part Specifications

Specifications could not be found.

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
A	14-0102	CHD TITLE BLOCK WAS RED BARN IS DART ADDED BAG & LABEL NOTE.	7/30/2014	DJN
				APPROVED RW



- NOTES:**
1. USE FIXTURE 20NR-64 F AS CASTING MOLD.
 2. RADIUS IS FOR SHRINKAGE NOT CRITICAL.
 3. BAG & LABEL WITH BATCH NUMBER.

USED ON
20NR
8NR

DART
AEROSPACE

FLAT BUMPER

TITLE:	FLAT BUMPER
DWG NO.	20NR-64
REV	A

MAT'L POLYURETHANE DRAWN BY: SMITH

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

XXX ± .005 FRACTIONS 1/32

XX ± .01 ANGLES ± 5°

1. BREAK ALL SHARP EDGES .015 X 45°

2. DIMENSIONAL LIMITS APPLY AFTER FINISH

SCALE 2:1 DATE 8/13/2013 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-64	1	FLAT BUMPER	POLYURETHANE	3/8 X 3/8 X 1-1/2

USED ON MODEL